

226.628.02

Date: Monday, 4/23/2007 1:37:50 PM  
User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L /407 STEP ASSY, RH			
Job Number	: 31977A						
Estimate Number	: 11703						
P.O. Number	: N/A		Part Number	: D2724042			
This Issue	4/23/2007	S.O. No.	: N/A		Drawing Number	: D2724 REV C	
Prsht Rev.	: NC		Project Number	: N/A			
First Issue	: N/A		Drawing Revision	: C			
Previous Run	: 31011A		Material	: N/A			
Written By	:		Due Date	: 5/10/2007 Qty: 4 Um: Each			
Checked & Approved By	:		Signature: 07.04.23				
Comment	: Est Rev:E As Per Ecn 766 06-01-06 JLM						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D2622120C	Extrusion		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Qty Part # Description Batch: 330199				
Check Material for any Dents or Defects				
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1		
Comment: LARGE FABRICATION RESOURCE 1				
Cut D2724-2 using D2622 extrusion as per Dwg D2724 Deburr and bevel ends for welding				
3.0	D2734	206 Step Endplate		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) 206 Step Endplate Pick: Qty Part Number Description Batch: 330883				
4.0	D34581	PLATE		
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s) Pick: Qty Part Number Description Batch: 332480				

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L /407 STEP ASSY, RH
Job Number: 31977A		Part Number: D2724042
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	D34583	PLATE
Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)		
Pick:		
Qty	Part Number	Description
2	D3458-3	Plate
Batch	832481 = 8	PL 01-02-03 4
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
Weld end cap and lugs as per Dwg D2724 using Jig DT		followed by Jig
DT	(One End Only)	
A/R	AL ROD	Batch: M102256
M104727		PL 01-02-04 4
Grind end cap welds flush		PL 01-02-04 4
		PL 01-02-05 4
7.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION		PL 01-02-05 4
8.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		PL 01-02-05 4
9.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1		PL 01-02-05 4
Chemical Conversion Coat as per QSI 005 4.1		PL 01-02-05 4
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION		PL 01-02-05 4
11.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1		
Inspect for foreign object per QSI 024		PL 01-02-05 4

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng					

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L /407 STEP ASSY, RH
Job Number: 31977A		Part Number: D2724042
Job Number: 		
Seq. #:	Machine Or Operation:	Description:
	Weld Remaining end cap as per Dwg D2724 using Jig DT DT A/R AL ROD Batch: <u>1102756</u>	<u>16.01.01.05</u>
	Grind end plate flush.	<u>0.1 01.01.09</u>
12.0	QC9	VISUAL WELDING INSPECTION 
	Comment: VISUAL WELDING INSPECTION	<u>1101/01/10(4)</u>
13.0	QC5	INSPECT WORK TO CURRENT STEP 
	Comment: INSPECT WORK TO CURRENT STEP	<u>2 En 07/07/10 x 4 LH</u>
14.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
	Comment: HAND FINISHING RESOURCE #1	
	Touch up Alodine	<u>Fd 07/07/18 (4)</u>
15.0	POWDER COATING	POWDER COATING 
	Comment: POWDER COATING	<u>M 104 144</u>
	Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3	<u>BR/M/107-07-18</u>
16.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<u>Fd 07/07/19 (4)</u>
17.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
	Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4	<u>M 104 942</u>
18.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION 
	Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	<u>1 (En 07/07/20 (4))</u>
19.0	PACKAGING 1	PACKAGING RESOURCE #1 
	Comment: PACKAGING RESOURCE #1	
	Identify and Stock Location: _____	<u>PPN 31597 07/17/20(8)</u>

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/04/23

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

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## Process Sheet

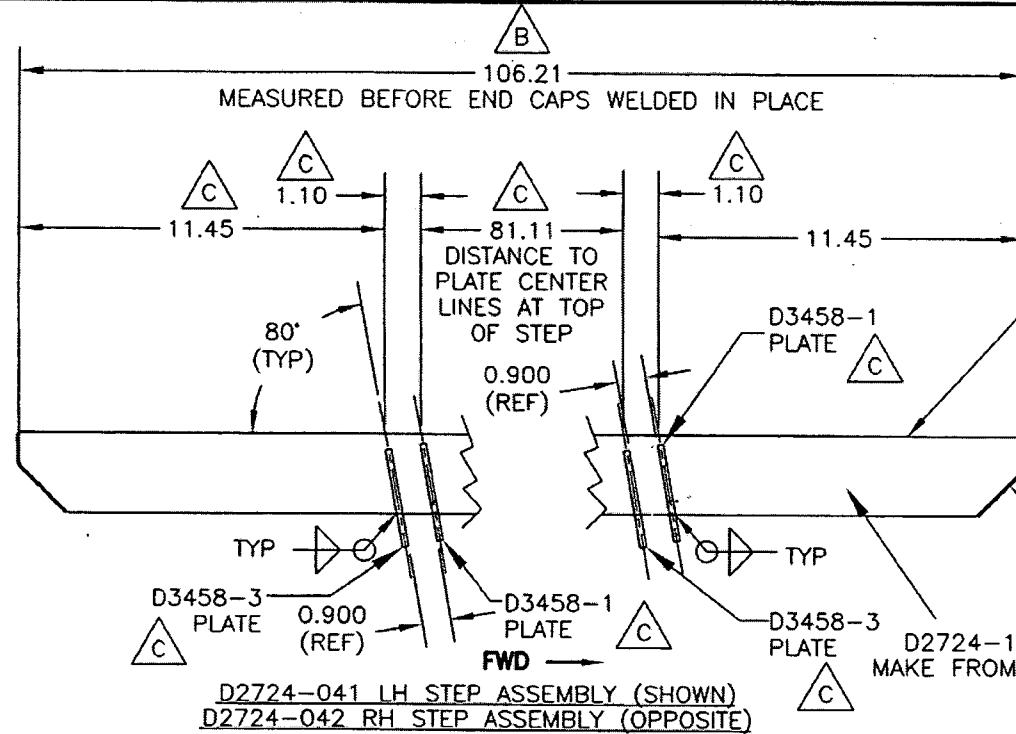
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: 206L /407 STEP ASSY, RH
Job Number: 31977A		Part Number: D2724042
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
20.0	QC21 	FINAL INSPECTION/W/O RELEASE  4 17/07/03
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

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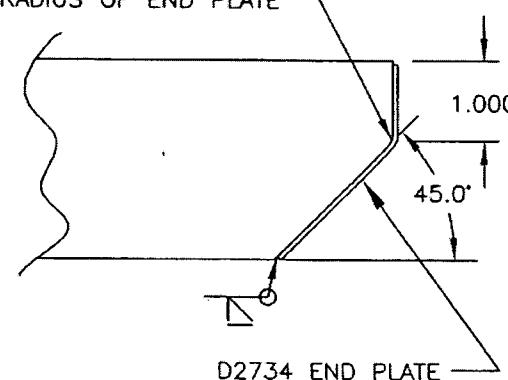
NOTE: ALL WELDS SHALL BE 100% VISUALLY INSPECTED BY A QUALIFIED INSPECTOR PER DART QSI 004

RELEASED  
05.11.14

DART

DESIGN KE		DRAWN BY PH	DART AEROSPACE USA, INC.	
CHECKED	APPROVED	PORT HADLOCK, WA		REV. C
		DRAWING NO.	SHEET 1 OF 1	
A		DATE	TITLE	SCALE
		05.09.19	97.12.04	NEW ISSUE
B			98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C		05.09.19	206L/407 STEP ASSEMBLY	RE-DESIGN, ADD D3458-1/-3

ROUND CORNER OF EXTRUSION TO MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL  
NOT TO SCALE

B

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-042		
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
31971A

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED